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RBBP-1404-1
Job Sheet 194166



Part No: RBBP-1404-1

Job Qty: 4 pcs

DAS
21
9-89

Part Name: K-Flex Drive Shaft Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/26/19

Job Tracking No:

Due Date: 6/14/19

9-27-2019

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG RBBP-1404-1 Rev.2 IPP Rev. A 18.11.12 New issue DP Verify DD

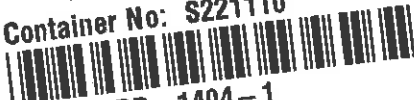
Ship Via:

Bill of Materials



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Container No: S221110



Part: RBBP-1404-1

Job No: 194166

Serial No/Batch: S221110

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 10/09/19

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	4 pcs	6/14/19	6/14/19	0.00	0.80	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	4 pcs	6/14/19	6/14/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
120	Packaging 3-1 - Stock - B4B	4 pcs	6/14/19	6/14/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
130	QC 21 - FG	4 pcs	6/14/19	6/14/19	0.00	0.00	QC 21 - FG - 21		MLL
							QC 21 - FG - 70		
							QC 21 - SA - 53		

Part Op 100 - Assemble as per DWG.
Descriptions:

Job BOM

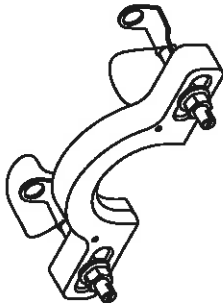
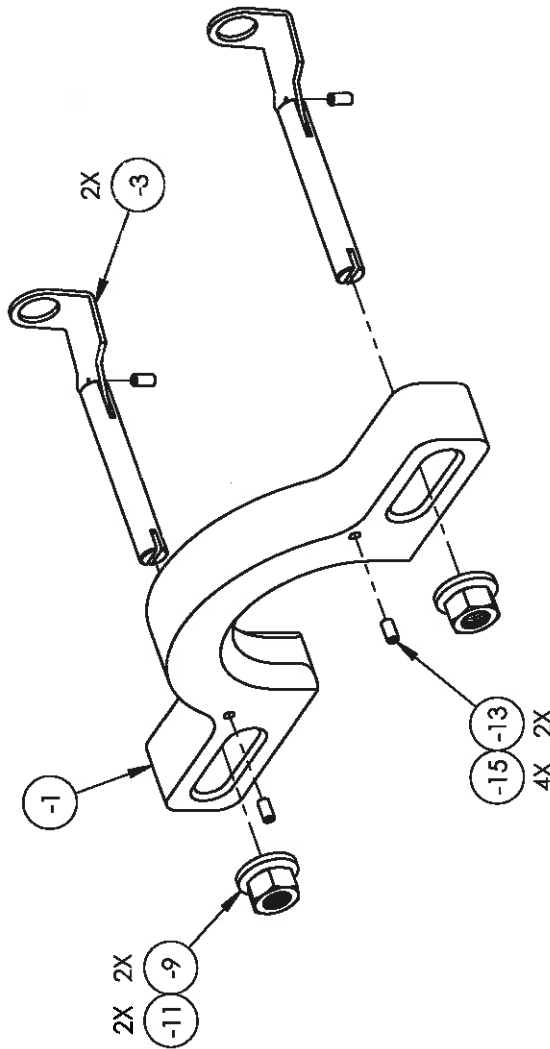
Part / Item	Component Name	Quantity	Operation	Container
3936T33	Stop Sleeve Rnd 1/32 X 1/4"	26 Ea (4 ea)	100-Small Fab - 1	5133305
8930T26	Coated Cable	4 ft (1 ea)	100-Small Fab - 1	5133324
95462A510	Hex Nut 5/16-24 - Steel Grade 5	8 Ea (2 ea)	100-Small Fab - 1	5133363
98023A030	Flat Washer 11/32 Id X 11/16 Od	8 Ea (2 ea)	100-Small Fab - 1	5133300
RBBP-1404-1-1	Block	4 pcs (1 ea)	100-Small Fab - 1	5142044
RBBP-1404-1-3	Weldment	8 pcs (2 ea)	100-Small Fab - 1	5146560

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	3936T33	16	47	0
	8930T26	4	9	0
	95462A510	8	98	0
	98023A030	8	48	0
	RBBP-1404-1-1	4	5	0
	RBBP-1404-1-3	8	2	0
Part Specifications				
Specifications could not be found.				

Plex 4/26/19 8:21 AM Dart.lajeunesse.marie

REVISIONS				
REV	ECR	DESCRIPTION	DATE	APPROVED
A		-9 CHD P/N FROM 91083A030 IN BOM. MADE ASSEMBLY DRAWING.	2/21/2011	RJC RW
2	16-0025	-3 CHD FINISH WAS CAD PLATE YELLOW IS ZINC PLATE. -7 ADDED FLAT PATTERN. -11 CHD P/N WAS 95505A612 IS 95462A510. CHD TOLERANCE ON NON-CRITICAL DIMENSIONS.	2/8/2016	RJC JAG

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WITHOUT NOTICE
V. 1.2 ORDER
NO. 194166 MJS
10/04/2016



TITLE K-FLEX DRIVE SHAFT TOOL									
DWG NO. RBBP-1404-1									
REV 2									
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS ± 1/8 ANGLES ± 5° SURFACES = 125/									
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R									
2. DIMENSIONAL LIMITS APPLY AFTER PLATING									
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009									
USED ON MODEL BELL 208B									
SCALE 1:2 DATE 1/14/2011 SHEET 1 OF 5									
ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS			
		-1	1	BLOCK	DELIN				
X		-3	2	WELDMENT					
1		-5		BOLT	ALL THREAD	5/16-24 (MCMASTER-CARR #99086A120) MODIFIED			
1		-7		EYE	1018/1020 CR				
	B/O	-9	2	FLAT WASHER	STEEL	Ø5/16 (MCMASTER-CARR #99023A030)			
	B/O	-11	2	HEX NUT	STEEL GRD 5	5/16-24 (MCMASTER-CARR #95462A510)			
	B/O	-13	2	COATED CABLE	S.S.	1/27 CABLE Ø1/32 X 6 (MCMASTER-CARR #8930726)			
	B/O	-15	4	STOP SLEEVE	COPPER	Ø1/32 X 1/4 (MCMASTER-CARR #9936133)			
ASSY -3									

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐				DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ ☐ Cross tube ☐ ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ ☐ Engineering ☐ ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐ ☐				Date : _____ Sequence #: _____		QTY Affected : _____		MRB (QS1042) _____									
Description Work Order Deviation						Disposition																	
Root Cause Operator ☐ ☐ ☐ ☐ ☐ Manufacturing Process ☐ ☐ ☐ ☐ ☐ Equip/Tooling ☐ ☐ ☐ ☐ ☐ Handling/Preservation ☐ ☐ ☐ ☐ ☐ Material ☐ ☐ ☐ ☐ ☐ Product Improvement ☐ ☐ ☐ ☐ ☐ Process Improvement ☐ ☐ ☐ ☐ ☐ Human Factors ☐ ☐ ☐ ☐ ☐						FAULT CATEGORY Contamination ☐ ☐ ☐ ☐ ☐ Misaligned/off center ☐ ☐ ☐ ☐ ☐ BOM/Route ☐ ☐ ☐ ☐ ☐ Broken/Damage/Defect ☐ ☐ ☐ ☐ ☐ Incomplete/Unclear Instructions ☐ ☐ ☐ ☐ ☐ Drill Holes ☐ ☐ ☐ ☐ ☐ Fit/Function ☐ ☐ ☐ ☐ ☐						Power Loss/Surge ☐ ☐ ☐ ☐ ☐ Folio/Program ☐ ☐ ☐ ☐ ☐ Grain Direction ☐ ☐ ☐ ☐ ☐ Weld ☐ ☐ ☐ ☐ ☐ Wrong Stock Pulled ☐ ☐ ☐ ☐ ☐ Out of Sequence ☐ ☐ ☐ ☐ ☐ Off-set/Set-up ☐ ☐ ☐ ☐ ☐						Positioned Wrong ☐ ☐ ☐ ☐ ☐ Outside Tolerance ☐ ☐ ☐ ☐ ☐ Drawing ☐ ☐ ☐ ☐ ☐ Finish ☐ ☐ ☐ ☐ ☐ Part Lost/Missing ☐ ☐ ☐ ☐ ☐ Misread ☐ ☐ ☐ ☐ ☐					
						Pressure/Forced ☐ ☐ ☐ ☐ ☐ Bending ☐ ☐ ☐ ☐ ☐ Crushing ☐ ☐ ☐ ☐ ☐ Cracks ☐ ☐ ☐ ☐ ☐ Crimp/Kink/Ripple/Wave/Twist ☐ ☐ ☐ ☐ ☐ Marks/Chatter ☐ ☐ ☐ ☐ ☐ Mislabeled ☐ ☐ ☐ ☐ ☐						Other/Details: _____											
						Completed By _____						Lead hand / Supervisor _____											
						QC / QA Coordinator _____						_____											